

Ship 17 Feb. 2017

Work Order ID 154697

154697

Page 1

Monday, December 19, 2016 2:20:07 PM

Item ID: D350-607-541 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid
Start Date: 12/30/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 1/12/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan:  Date: DEC 19 2016 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D350-607-3	D
DSI9699	A

Label 17-01-30

100	Document Control	JAN 28 2017	0.00	DAS 6 9-89		DAS 28 9-89		FEB 17 2017
100	DOCUMENT CONTROL							
DC	Memo		0.00					
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-541 CHG007							

110	Pick Kit		0.00					
110								
Packaging	Memo		0.11					
Packaging								

JAN 28 2017

DAS 6 9-89 DAS 28 9-89 DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Work Order ID 154697***154697***

Page 2

Monday, December 19, 2016 2:20:07 PM

Item ID: D350-607-541**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid**Start Date:** 12/30/2016 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/12/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging	Package as per PPPD350-607-541								
	BK003								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS
28
9-89DAS
28
9-89
FEB 02 2017DAS
28
9-89DAS
27
9-89

FEB 03 2017

DAS
21
9-89

FEB 06 2017

M

FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Monday, December 19, 2016 2:20:06 PM

Page 1

Work Order ID: 154697

154697

Parent Item: D350-607-541

D350-607-541

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid

Start Date: 12/30/2016

Required Date: 1/12/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B
11.02.09 add to install label DD verf by:EC IPP REV:C 12.03.06
AS PER ECN12-535 DD VERF:EC IPP REV:D 12.07.24 AS PER
ECN 12-610 DD VERF:EC IPP REV:E 13.08.21 CHG005 / ECN 13-
624 DD VERF:JLM IPP REV:F 14.06.09 AS PER ECN14-572 DD
VERF:JLM IPP REV:G 16.09.12 added note at seq120 PAR16-515 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4086-200

Manufactured

No

110

Each

10.0000

1

1

D4086-200

Placard, Max Load

**

JAN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST078

10

153070

6

151299

4

10/12/2017

154450

D4917-300

Manufactured

No

110

Each

12.0000

1

1

D4917-300

Placard, Max Load

**

JAN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST137

12

153092

6

153294

6

11/21/2017

11/25/2017

1

D350-607-511

Manufactured

No

110

Each

2.0000

1

1

D350-607-511

AS350/AS355 Quick Release Basket/Long Cargo Tube Mounting Provisions, Fits LH/RH

**

JAN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

FG128

2

149510

2

150898

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Monday, December 19, 2016 2:20:06 PM

Page 2

Work Order ID: 154697

154697

Parent Item: D350-607-541

D350-607-541

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid

Start Date: 12/30/2016

Required Date: 1/12/2017

Start Qty: 1.00

Required Qty: 1.00

D2690-6 Manufactured No

110 Each

65.0000

1 1

D2690-6

Lanyard

**

JAN 28 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST009

35

151983

5

152878

30

ST012a

30

154343

30

D3912-041

Manufactured No

110 Each

7.0000

1 1

D3912-041

Eyebolt Receiver Assembly

**

JAN 28 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST057

7

149505

7

D4030-041

Manufactured No

110 Each

0.0000

1 1

D4030-041

Long Basket Assembly (350)

**

154697

JAN 28 2017

DAS 6 27 9-89

DAS 28 9-89

D4151-041

Manufactured No

110 Each

17.0000

1 1

D4151-041

Basket Fwd Hardpoint Assembly, Lower

**

JAN 28 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST087

1

151037

1

ST090A

16

151038

5

151434

5

151711

2

153090

4

Monday, December 19, 2016 2:20:07 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Page 3

Work Order ID: 154697

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Parent Item: D350-607-541

D350-607-541

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid

Start Date: 12/30/2016

Required Date: 1/12/2017

Start Qty: 1.00

Required Qty: 1.00

D4151-043

Manufactured No

110

Each

15.0000

1

1

D4151-043

Basket Fwd Hardpoint Assembly, Upper

**

JAN 28 2017

Location

Loc Qty

Loc Code

ST088

9

149689

3

151135

4

151804

2

ST090A

6

152475

2

153150

4

D4150-041

Manufactured No

110

Each

15.0000

1

1

D4150-041

Attachment Arm Assembly

**

JAN 28 2017

Location

Loc Qty

Loc Code

ST087

9

149663

9

ST090A

6

152256

2

153117

4

DAS
28
9-89

DAS
28
9-89

DAS
D/27
6-9-89
9-89

DAS
6
9-89
DAS
27
9-89

DQA: _____ Date: _____



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Handling/Pre ☐	Training ☐																																																																				
Material ☐	Use for Testing ☐																																																																				
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Tribal Knowledge ☐	Rushing ☐																																																																				
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Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER :																																																																					

Picklist Print

Monday, December 19, 2016 2:20:07 PM

Page 4

Work Order ID: 154697

154697

Parent Item: D350-607-541

D350-607-541

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid

Start Date: 12/30/2016

Required Date: 1/12/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No

110 Each

628.0000

6 6

AN4-13A

Bolt

**

JAN 28 2017

DAS 27
6 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

FG	20	
122808	20	
GA	76	
m134634	19	
m135470	57	
over003	350	
m136263	250	
m136406	100	
ST344	182	
m136147	182	

136605

AN4C15 Purchased No

110 Each

39.0000

1 1

AN4C15

Bolt

**

JAN 28 2017

DAS 27
6 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

OVER002	20	
M136182	20	
ST343	19	
M135704	19	

1

AN310C4 Purchased No

110 Each

74.0000

1 1

AN310C4

Nut

**

JAN 28 2017

DAS 27
6 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

OVER007	64	
M135297	29	
M135895	35	
ST331	10	
M134762	10	

1

Monday, December 19, 2016 2:20:07 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Environment ☐	No Re-verification ☐																																																																			
Design ☐	Operator ☐																																																																			
Doc/Data ☐	Offset/Setup ☐																																																																			
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Mislabeled ☐	Finish ☐																																																																			
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Misaligned/off center ☐	Turning Sequence ☐																																																																			

Picklist Print

Monday, December 19, 2016 2:20:07 PM

Page 5

Work Order ID: 154697

154697

Parent Item: D350-607-541

D350-607-541

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid

Start Date: 12/30/2016

Required Date: 1/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS17984-C413

Purchased

No

110

Each

38.0000

1 1

MS17984-C413

Quick Release Pin

**

JAN 28 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

over005

35

151622

10

153303

15

153942

10

ST315

3

150872

3

MS21042L4

Purchased

No

110

Each

2,376.000

6 6

MS21042L4

Nut

**

JAN 28 2017

DAS 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

192

m135058

192

OVER007

1500

m136182

500

m136295

1000

ST303

666

m135864

166

m135979

500

Monday, December 19, 2016 2:20:07 PM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : _____							

Picklist Print

Monday, December 19, 2016 2:20:07 PM

Page 6

Work Order ID: 154697

154697

Parent Item: D350-607-541

D350-607-541

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid

Start Date: 12/30/2016

Required Date: 1/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

110

Each

201.0000

1

1

MS24665-151

Cotter Pin

**

JAN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

60

m128401

60

ST289

141

m135274

41

m136444

100

DAS
27
9-89
DAS
6
9-89

NAS1515H4L

Purchased

No

110

Each

443.0000

2

2

***NAS1515H4L ***

Washer

**

JAN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

23

103691

3

m132189

20

ST260

44

m131026

44

ST260a

376

m131697

63

m132189

87

m133483

138

m134376

88

DAS
27
9-89
DAS
6
9-89

NAS1149F0432P

Purchased

No

110

Each

1,993.000

12

12

NAS1149F0432P

WASHER

**

JAN 28 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

1000

M136442

1000

ST262

993

M135704

993

DAS
27
9-89
DAS
6
9-89

Monday, December 19, 2016 2:20:07 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 7

Monday, December 19, 2016 2:20:07 PM

Work Order ID: 154697

154697

Parent Item: D350-607-541

D350-607-541

Parent Item Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid

Start Date: 12/30/2016

Required Date: 1/12/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0463R

Purchased

No

110

Each

387.0000

3

3

NAS1149C0463R

Washer

**

JAN 28 2017

DAS
6
9-89
27
9-89

Location

Loc Qty

Loc Code

FP001

39

m127306

39

ST266

348

m134167

148

m136263

200

DAS
28
9-89

~~3/1/80~~

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6

REF TCCA STC: SH94-14
REF FAA STC: SR00213N1
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-548 @ CHG 006, D350-607-547 @ CHG 007 Hell-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-541	-543	-545	-547	-511	-501	D350-607-541	HELL-UTILITY-BASKET @ CHG 007 OR LATER
X	X					D350-607-543	HELL-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELL-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELL-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
				X		D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-413	-415	-511	-431	-419	-431	D350-607-413	HEAVY DUTY LID KIT (LONG)
X	X					D350-607-415	HEAVY DUTY LID KIT (SHORT)
				X		D350-607-417	LIGHTWEIGHT LID KIT (LONG)
				X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X		D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-641	-611	-511	-431	D350-607-641	QUICK RELEASE LONG CARGO TUBE
X	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR.	N/A		
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DATE	14.05.16		
DART AEROSPACE LTD		REV. A	
HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 2	
DRAWING NO. DSI 9699		SCALE NTS	
TITLE LUG REPLACEMENT			

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3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.

3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).

3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

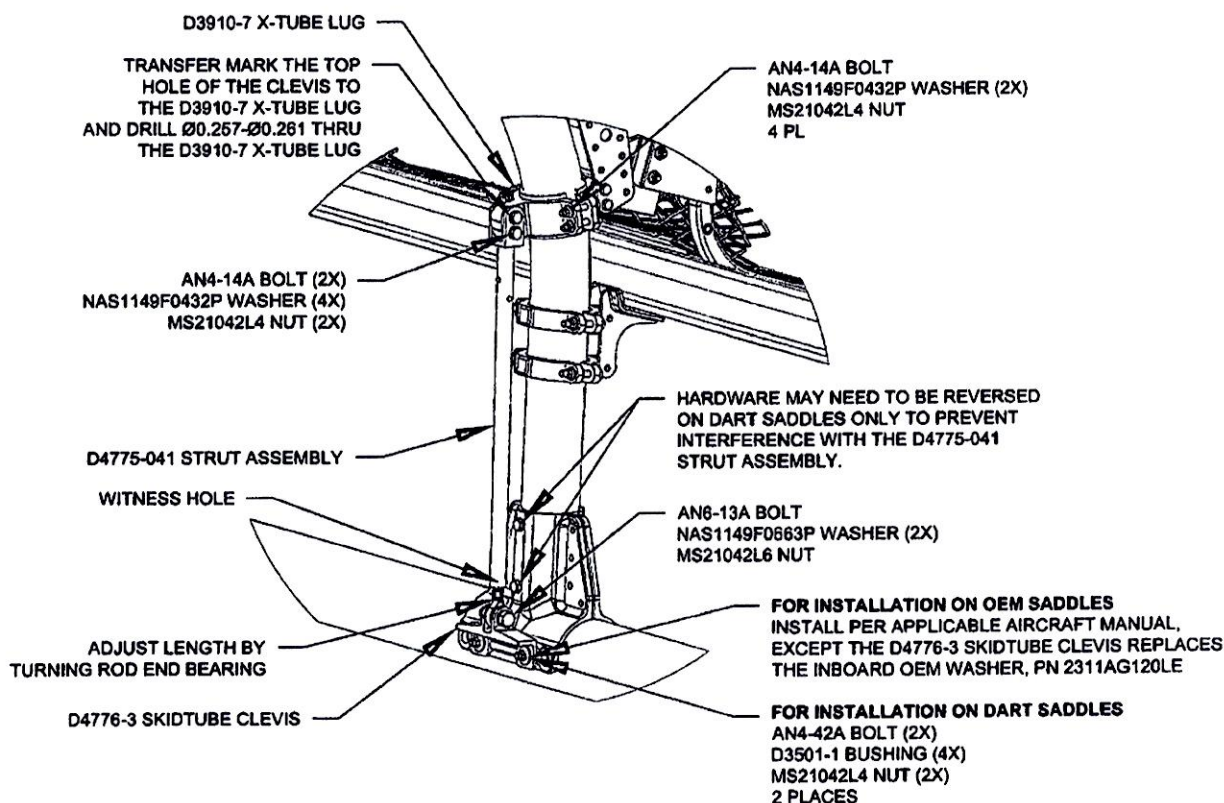


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

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BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

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5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				2	2	D3910-5	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: EASA.10016996
REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

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